

Date: Tuesday, 21/10/2008 2:45:56 PM
 User: Julie Dawson

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services		Drawing Name	WEARSHOE	
Job Number	42776		Part Number	D265621	
Estimate Number	10614		Drawing Number	D2656 REV D	
P.O. Number			Project Number	N/A	
This Issue	21/10/2008 S.O. No. :		Drawing Revision	D	
Prsht Rev.	NC		Material		
First Issue	/ / Type : SMALL /MED FAB		Due Date	04/11/2008 Qty: 10 Um: Each	
Previous Run	38748				
Written By					
Checked & Approved By	<u>JUL 08-10-21</u>				
Comment	: Est: D 02.10.25 Re-format KJ Est Rev:E Now on Waterjet 06-11-02 JLM				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M1010S20GA	1010/1025 SHEET
		Comment: Qty.: 0.9371 sf(s)/Unit Total : 9.3713 sf(s) 1018 20 ga .040" thk Batch: <u>109289</u> <u>B 8-11-6</u>
2.0	WATER JET	FLOW WATER JET
		Comment: FLOW WATER JET 1-Cut as per Dwg D2656 Dwg Rev: <u>D</u> <u>B 8-11-6</u> Prog Rev: <u>D</u>
		2-Deburr if necessary <u>B 8-11-6</u>
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		<u>B 8-11-6</u>
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE
4.0	QC8	SECOND CHECK
		<u>S 001110 X13</u>
		Comment: SECOND CHECK
5.0	BRAKE NC	NC BRAKE
		Comment: NC BRAKE Form bend & joggle as per Dwg D2656 using DT8261 & DT8326
		<u>E208/11/11 (13)</u>

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 21/10/2008 2:45:56 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARSHOE

Job Number: 42776

Part Number: D265621

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 08/11/12

(3)

7.0 POWDER COATING

POWDER COATING



M 106442

(3X)

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME:

10:15

OVEN TEMPERATURE:

320°F

FINISH TIME:

10:45

m/l 08/11/13

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



40

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-11-13

(X13)

9.0 PACKAGING 1

PACKAGING RESOURCE #1



(13X)

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

F P - 20

m/l 08/11/13

10.0 QC21

FINAL INSPECTION/W/O RELEASE



08/11/14

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-11-13

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	427X
Description: Wearshoe	Part Number:	D2656-21
Inspection Dwg: D2656	Rev: D	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

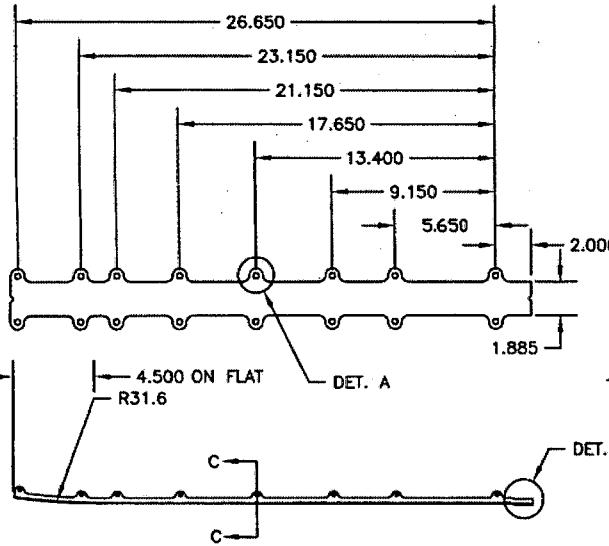
X First Article Prototype

Measured by:	<u>BS</u>	Audited by:	<u>✓</u>	Prototype Approval:	N/A
Date:	8-11-6	Date:	08/10/10	Date:	N/A

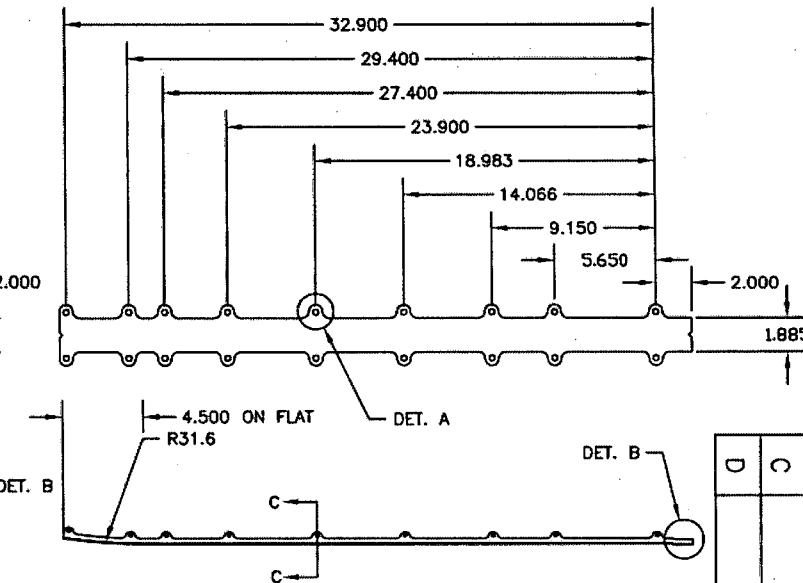
Rev	Date	Change	Revised by	Approved
A	08.02.28	New Issue	KJ/DD	

DART

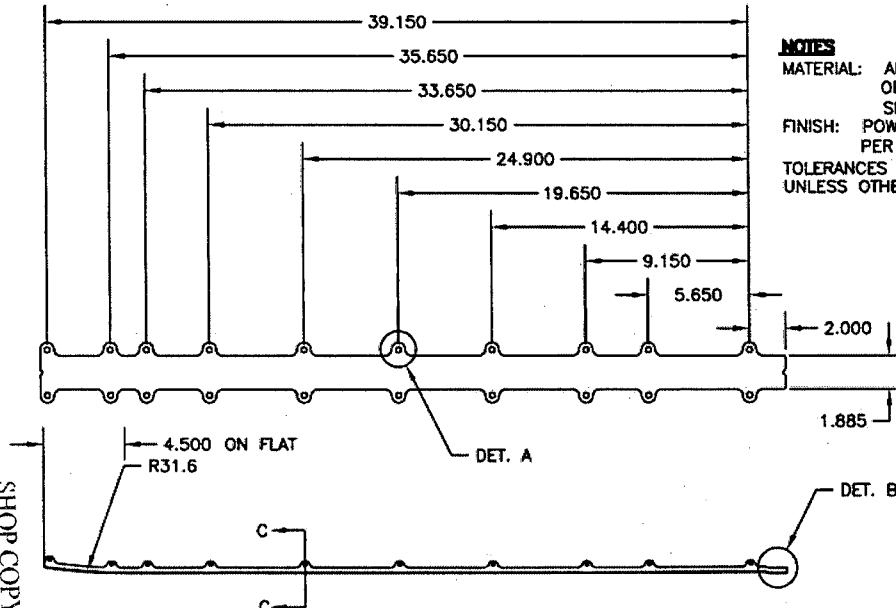
D2656-11



D2656-13



D2656-15



NOTES

MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008
OR CSA G40-21, 38W/44W/50W/60W/70W
SERIES STEEL, 20 GAUGE (0.040 THICK)
FINISH: POWDER COAT GREY SANTEX (4.3.5.6)
TOLERANCES ARE PER QSI 005 4.3
PER QSI 005 4.3
UNLESS OTHERWISE NOTED

RELEASED
05-09-06 #

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
DS	CP	PRT HADLOCK, WA
		REV. D
		DRAWING NO.
		D2656
		SHEET 1 OF 4
DATE	TITLE	SCALE
05.08.17	WEARSHOE	1:10
A	97.03.25	
B	97.06.02	CHANGED TABS
C	97.06.26	R31.6 WAS R19.5
D	05.08.17	ENLARGE ALL HOLES TO IMPROVE FIT

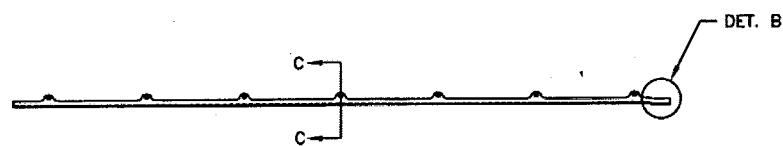
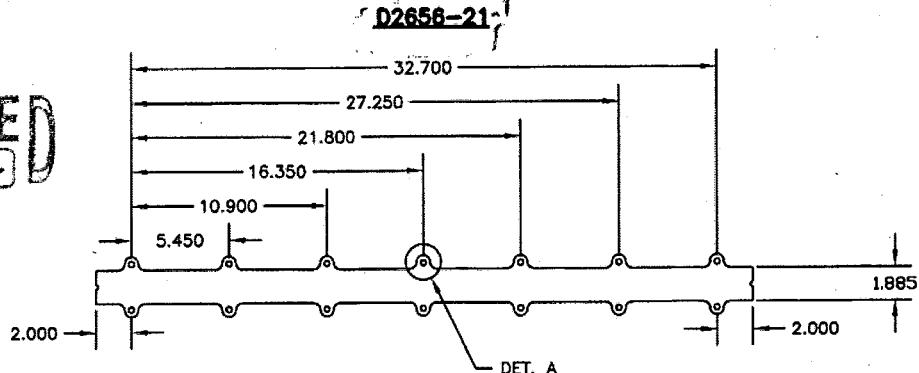
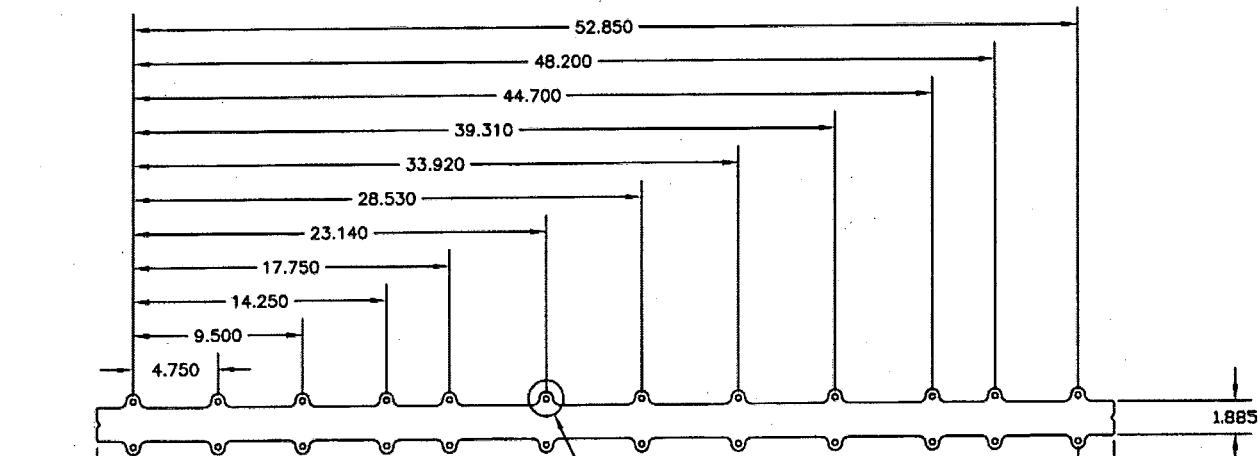
ENGINEERING
COPY
RETURN TO
SHOP COPY

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED
OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC. SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER
NO. 4016

DART

DESIGN DS	DRAWN BY CP	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED <i>A</i>	APPROVED <i>H</i>	DRAWING NO. D2656 REV. D SHEET 2 OF 4
DATE 05.08.17	TITLE WEARSHOE	SCALE 1:10

RELEASED
05.09.06 *f***D2656-23****NOTES**

MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W
SERIES STEEL, 20 GAUGE (0.040 THICK)

FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER QSI 005 4.3
TOLERANCES ARE PER DART QSI 018
UNLESS OTHERWISE NOTED

SHOP COPY

RETURN TO
ENGINEERING

UNCONTROLLED COPY

SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

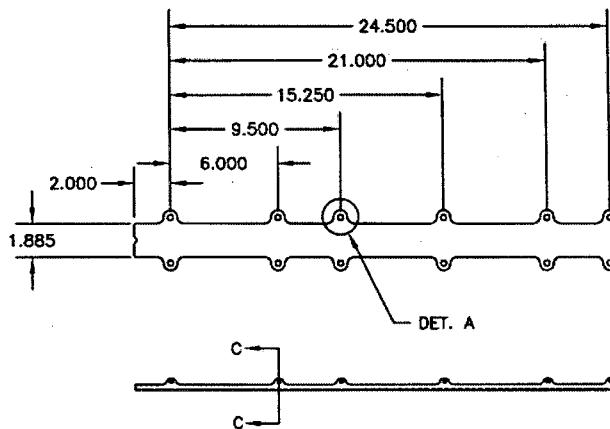
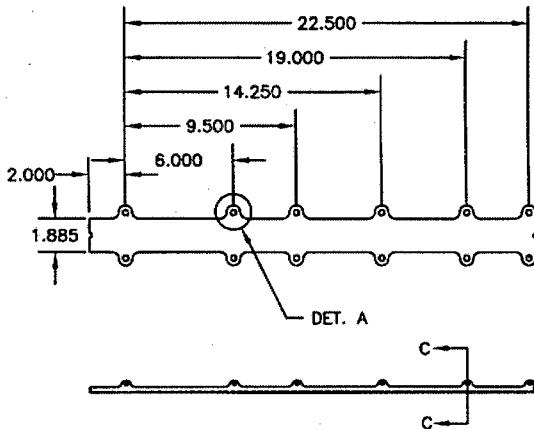
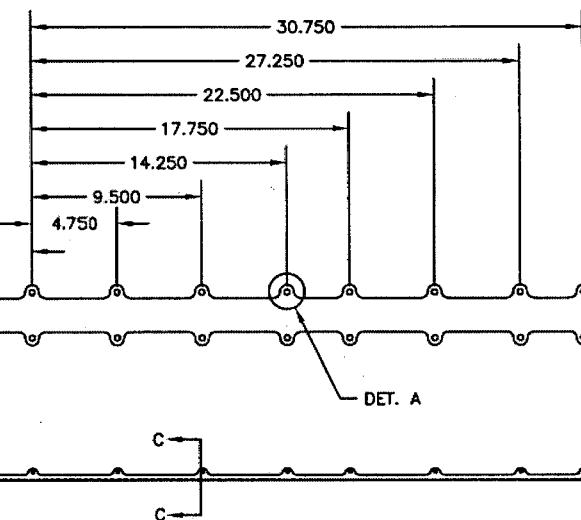
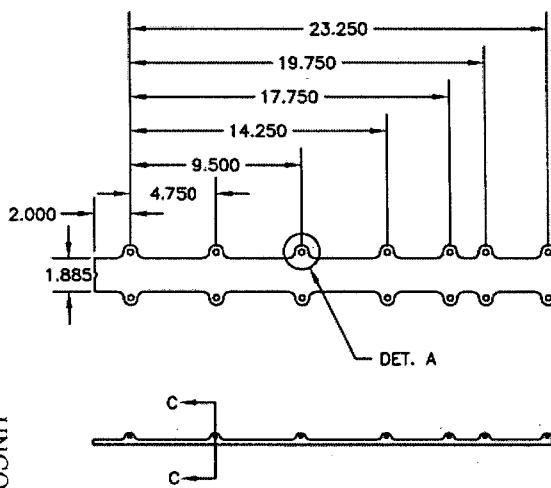
Copyright © 1997 by DART AEROSPACE USA, INC.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED
OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

NO *07/10*

DART

DESIGN	DS	DRAWN BY	C.P.	DART AEROSPACE USA, INC.
CHECKED	<i>[initials]</i>	APPROVED	<i>[initials]</i>	PORT HADLOCK, WA
DATE	05.08.17	DRAWING NO.	D2656	REV. D
TITLE	WEARSHOE	SHEET 3 OF 4	SCALE	1:10

D2656-33**D2656-31****D2656-37****D2656-35****RELEASED**
05.07.06
*[initials]***NOTES**

MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W
SERIES STEEL 20 GAUGE (0.040 THICK)
FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER QSI 005 4.3
TOLERANCES ARE PER DART QSI 018
UNLESS OTHERWISE NOTED

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
NO. *[Signature]*
SHOP COPY
RETURN TO
ENGINEERING
NO. *[Signature]*

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE NOT STATED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC. WORKS PROJECT #

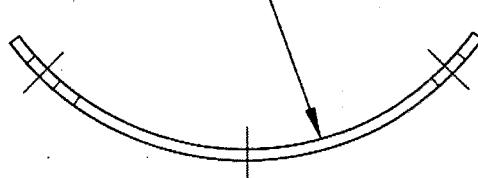
Copyright © 1997 by DART AEROSPACE USA, INC.



DESIGN DS	DRAWN BY CP	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2656	REV. D SHEET 4 OF 4
DATE 05.08.17	TITLE WEARSHOE	SCALE 1:10	

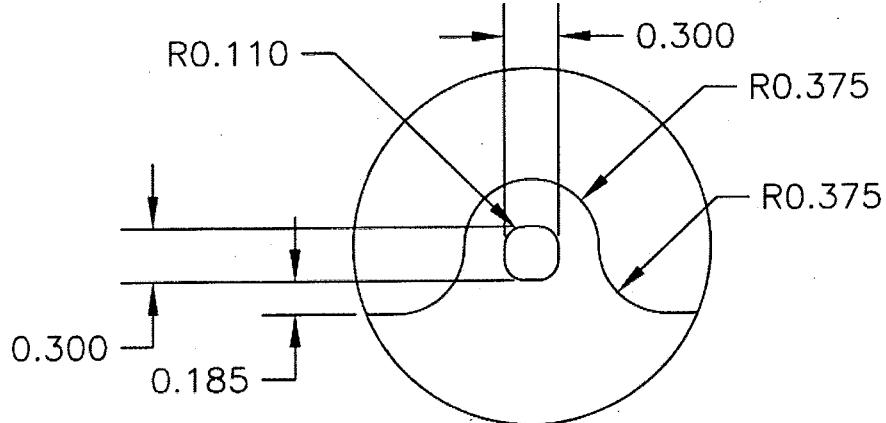
SECTION C-C

R1.62

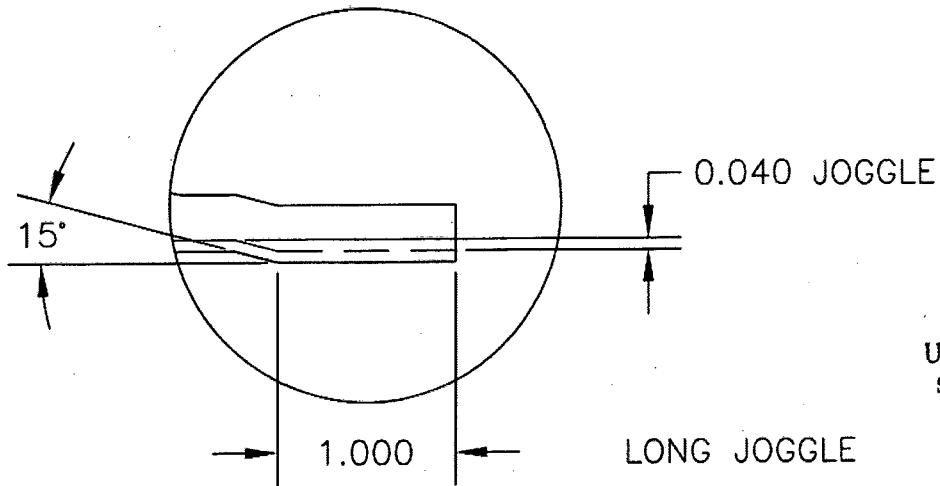


RELEASED
05.09.06 *[Signature]*

DETAIL A



DETAIL B



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *42700*

Copyright © 1997 by DART AEROSPACE USA, INC.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.